

Work Order ID 64703



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Tuesday, December 14, 2010 1:12:32 PM

Item ID: D350-589-011

Accept



Setup Start



Revision ID:

Item Name: Side Door Latch Modification

Stop



Start Date: 12/14/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

PK

Date: 10/12/14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

INN-D350-589

E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type label as per PPP D350-589-011 CHG002

Sulaloz

OK per CL 10/12/14

105

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/12/30 (52) SD

110

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Sulaloz

(75)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 12/14/2010 Start Qty: 5.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



Packaging

Packaging

Raw

0.00

Loc 22

11/01/07

52

Packaging

Memo

0.00

Identify and pack for shipping as per QSI 014

130



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CK 11/01/07

ME

11-01-07

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Picklist Print

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Work Order ID: 64703

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 12/14/2010

Required Date: 12/22/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP F02.08.29 Removed D2587 Plug KJ
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD10

NAS1149D0363J

Purchased

No

105

Each

8.0000

3

15



Washer



M115622 10/12/30sf

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

D2237

Manufactured

No

105

Each

1.0000

3

15



Striker Plate



B64426 11/1/4 sf

Location

Loc Qty

Loc Code

ST010

1

62212

1

D2583

Manufactured

No

105

Each

31.0000

3

15



Latch Bracket



10/12/30sf

Location

Loc Qty

Loc Code

ST017

29

64313

29

ST018

2

56527

2

13
1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 64703

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 12/14/2010

Required Date: 12/22/2010

Start Qty: 5.00

Required Qty: 5.00

D2585

Manufactured No

105 Each

3.0000

3

15

Mounting Channel

Location

Loc Qty

Loc Code

ST018

3

62676

3

D2586

Manufactured No

105 Each

0.0000

3

15

Door Latch

D2587

Manufactured No

105 Each

33.0000

1

5

Door Slug, 350 Hinge

Location

Loc Qty

Loc Code

ST018

33

64314

33

D2589

Manufactured No

105 Each

128.0000

1

5

Keys, Key Chain, 350 Hinge

Location

Loc Qty

Loc Code

ST019

128

58194

128

MS20470AD4-5

Purchased No

105 Each

1,612.000

6

30

Rivet, Universal Head

Location

Loc Qty

Loc Code

ST309

112

114761

112

ST319

1500

116410

1500

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification



Start Date: 12/14/2010

Required Date: 12/22/2010

Start Qty: 5.00

Required Qty: 5.00

MS21042L3

Purchased

No

105

Each

2,030.000

3



Nut



15

10/12/305

Location

Loc Qty

Loc Code

ST300

2030

114784

34

115835

996

116373

100

116391

900

15

MS27039-1-15

Purchased

No

105

Each

98.0000

3



Screw



15

10/12/305 (54)

Location

Loc Qty

Loc Code

ST292

98

114718

1

116169

97

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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52-00-00